

Date: Thursday, 17/07/2008 11:45:40 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARPAW KIT (19"X24")
Job Number :	40581		
Estimate Number :	10323		
P.O. Number :		Part Number :	D206559013
This Issue :	17/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2432 REV F3
First Issue :	/ /	Project Number :	N/A
Previous Run :	38171	Drawing Revision :	F3
Written By :		Material :	
Checked & Approved By :	JUL 08.7.17	Due Date :	06/08/2008
Comment :	Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 07-01-02 Was K10008 JLM Est Rev:L 08-01-09 Added Step 2 JLM Verified By:EC Est Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC		
		Qty:	5 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUL 08/7/29



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

80867/09

2.0	MFG ENGINEERING	MFG ENGINEERING
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 Comment: MFG ENGINEERING
 Program Batch Number

JUL 08-07-21

3.0	MUHMWB10	UHMW 1" Black
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 Comment: Qty.: 6.9878 sf(s)/Unit Total : 34.9388 sf(s)
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: M108645

Y.A 08/07/25

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

JUL

08/07/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SID

08/07/26

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8F 08/07/28

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

8.0

D2182B

Rubber Cushion



Comment: Qty.: 2.6000 f(s)/Unit Total : 13.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion 399P6

73

PC

9.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block 38173

2 D2432F(ref only) Bearpaw 40581

5

PC

10.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp 37852

5

PC

8/7/28

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Job Number:



Seq. #: Machine Or Operation: Description :

11.0 D2529 Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

37210 4P

381188 56P

Lu

12.0 D2732 Rubber Extrusion



Comment: Qty.: 2.6000 f(s)/Unit Total : 13.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050

Rubber Cushion

~~37632~~ 37632

Lu

13.0 AN415A Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

1107737

Lu

14.0 AN417A Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

1107321

Lu

15.0 AN960JD416 Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

1107738

Lu 28 (5)

Dart Aerospace Ltd

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4)

710 2478

8/7/28 (5)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

808/4/29 (x5)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location:

Rev A

808/4/29 (x5)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/30

Job Completion



MF 08-07-29

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

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 40581
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	/			
B	5.500	+/-0.030	5.500	/			
C	0.200	+/-0.030	0.200	/			
D	0.25 x 45°	+/-0.030	0.25 x 45°	/			
E	R0.250	+/-0.030	R.250	/			
F	0.250	+/-0.010	0.254	/			
G	0.625	+/-0.030	0.628	/			
H	0.375	+/-0.010	0.375	/			
I	0.950	+0.030/0.010	0.953	/			
J	19.000	+/-0.030	19.000	/			
K	3.14	+/-0.030	3.14	/			
L	3.28	+/-0.030	3.28	/			
M	Ø0.260	+0.005/-0.000	Ø.260	/			
N	Ø0.93	+/-0.030	Ø.928	/			
O	0.30	+0.030/-0.000	0.30	/			
P	23.750	+/-0.030	23.750	/			
Q	7.375	+/-0.030	7.375	/			
R	4.250	+/-0.010	4.250	/			
S	2.000	+/-0.030	2.000	/			
T	9.000	+/-0.010	9.000	/			
U	9.000	+/-0.010	9.000	/			
V	0.375	+/-0.010	0.378	/			

Measured by: 	Audited by: 	Prototype Approval: N/A
Date: 08/07/27	Date: 08/07/25	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF 	

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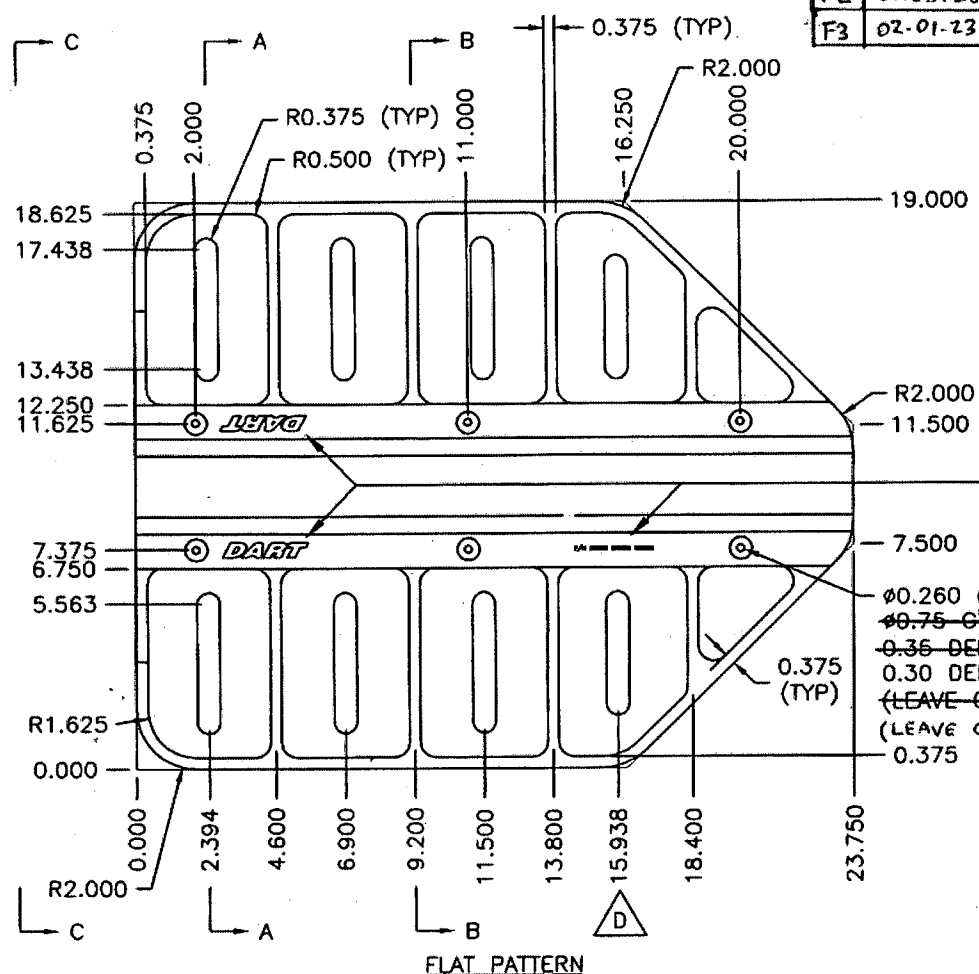
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV. F
KE	KE	D2432	SHEET 1 OF 2
CHECKED	APPROVED	DATE	SCALE
MM	MM	98.05.12	1:6

RELEASED
98.06.17 KE

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF



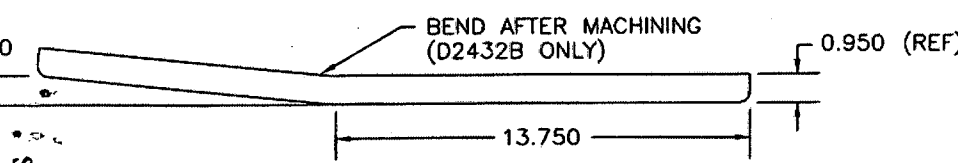
ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
0.375
(LEAVE 0.650 MIN.)

EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)



NO. 40581
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

W/O:		WORK ORDER CHANGES					
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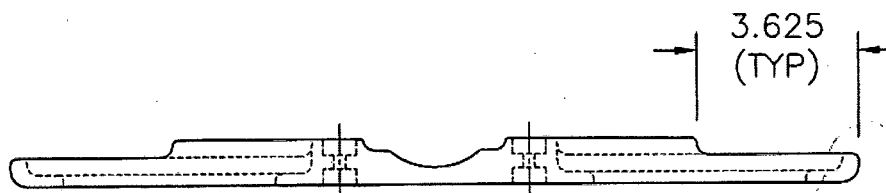
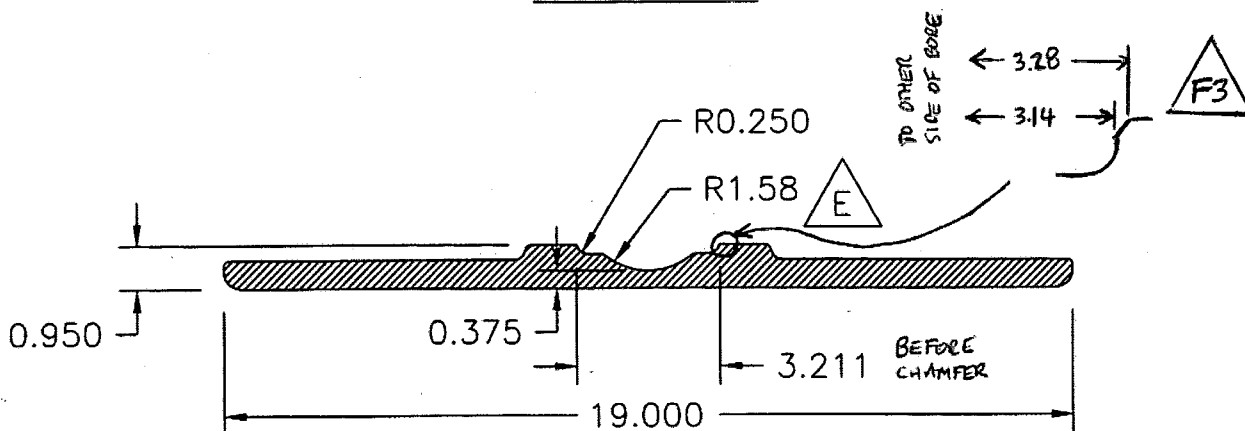
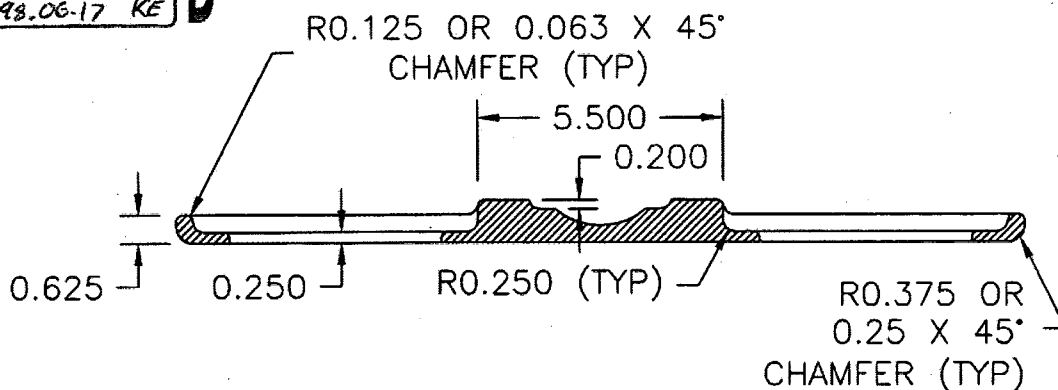
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ME	APPROVED KE	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40581

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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